

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017348**Date Inspected:** 11-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tom Pasqualone**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joints E7/E8 – A1, outside the OBG section: QC Inspector Tom Pasqualone was performing Ultrasonic Testing on the production weld.
- 2) At weld joint E6/E7 E-1 and 2, outside the OBG section: ABF welding Rory Hogan (#3186) and Jeremy Dolan (#5042) were performing Flux Cored Arc Welding (FCAW). QC Inspector Tony Sherwood was present and monitoring the work.
- 3) At weld joint W7/W8, inside the OBG section: ABF welding personnel James Zhen (#6001) was setting up equipment to start performing Submerged Arc Welding (SAW).

At weld joints E7/E8 – A1, outside the OBG section this QA Inspector observed QC Inspector Tom Pasqualone performing UT inspections. This QA Inspector observed QC Inspector Tom Pasqualone using what appeared to be a 70 degree shear wave transducer/wedge combination to perform the inspection. This QA Inspector observed the scanning pattern being used and the signals on the screen presentation. QC Inspector Tom Pasqualone had discovered an indication in the weld area and was trying to obtain a relevant signal from both faces of the weld for

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verification. The work observed by this QA Inspector appeared to comply with the contract requirements.

At weld joint E6/E7 E-1 and 2, outside the OBG section this QA Inspector observed ABF welding Rory Hogan (#3186) and Jeremy Dolan (#5042) were performing FCAW. This QA Inspector observed QC Inspector Tony Sherwood verify the following welding parameters; 245 amperes and 24.3 volts at travel speed of 192 mm per minute for a heat input value of 1.86 kJ per mm. The welding observed appeared to comply with ABF-WPS-D15-3040-A3.

At weld joint W7/W8, inside the OBG section this QA Inspector observed ABF welding personnel James Zhen (#6001) was setting up the track system, ventilation ducts and staging welding equipment in preparation to start performing Submerged Arc Welding (SAW).

This QA Inspector performed a walk through the East and West OBG sections for verification of the status of the various "D" weld joints and updated any repairs performed.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hager,Craig	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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